

Work Order ID 70724

Tuesday, June 14, 2011 7:17:22 AM

Page 1

Item ID: D2327-3

Accept

Revision ID:

Item Name: Spacer Bushing

Start Date: 6/15/2011 Start Qty: 20.00

Required Date: 6/17/2011 Req'd Qty: 20.00

Reference:

FA 11-06-14

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2327

Rev D

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn per Folio FA232 and Dwg D2327 ☐ Debar*FA 11/6/14**20*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*FA 11/6/14**20*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

FA 11-6-14 20

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Item ID: D2327-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer Bushing

Start Date: 6/15/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <i>WAS</i>	0.00							
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11-06-14 *11/6/15* *MF*
11-06-14

Picklist Print

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Page 1

Work Order ID: 70724

Parent Item: D2327-3

Parent Item Name: Spacer Bushing



Start Date: 6/15/2011

Required Date: 6/17/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP F05.11.02 Removed 303 SS KJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R0.375

Purchased

No

100

f

28.4100

0.1563

3.290526



304 ROUND BAR 0.375



SN 11614

Location

Loc Qty

Loc Code

MAT029

28.41

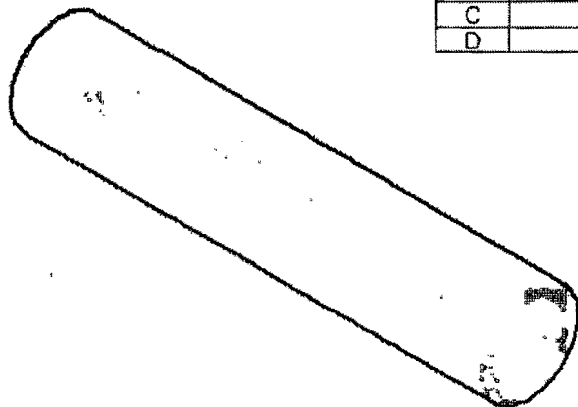
117130

28.41

3.2 PF



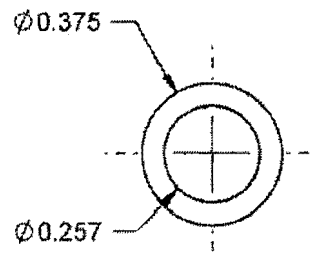
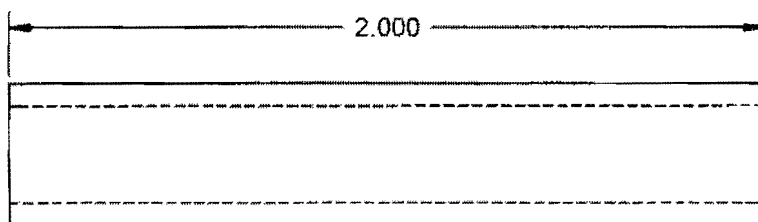
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED CH	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12	TITLE SPACER BUSHING SCALE 2:1		
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	



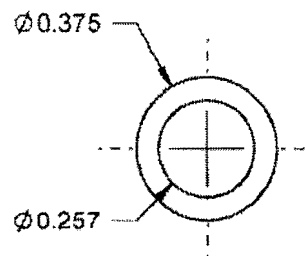
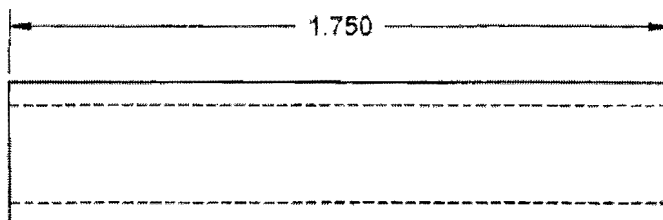
RELEASED

06.11.14

w/o 70724



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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